

Date: Thursday, 5/3/2007 11:39:12 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 32205	
Estimate Number : 12487	
P.O. Number : <u>N/A</u>	Part Number : D35021
This Issue : 5/3/2007	Drawing Number : D3502 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : B
Previous Run : 31936	Material : <u>N/A</u>
Written By : <u>JA 07.05.03</u>	Due Date : 6/10/2007
Checked & Approved By : <u>JA 07.05.03</u>	Qty: <u>44</u> <u>20</u> Um: Each
Comment : Est Rev:A New Issue 06-07-06 JLM Est Rev:B Add tooling hole 07-03-28	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"
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Comment: Qty.: 0.3035 f(s)/Unit Total : 6.0690 f(s)
6061-T6 Bar 1.0" x 4.0"
batch: M11941

BC 07.06.11

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 3.475" long

BC 07.06.11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: B

2-Deburr per dwg D3502

SA/BC 07.06.11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA/BC 07.06.11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07.06.11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:39:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 32205

Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill as per Dwg D3502.

SAD 07/07/04 (44)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

07-07-06 (44)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 101575

BR/FV 07-07-10 (44)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/7/13 (44) SP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

7/7/13 (44) SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.16 (44)

Job Completion



U 07-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32205
Description: Support		Part Number:	D3502-1
Inspection Dwg: D3502 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

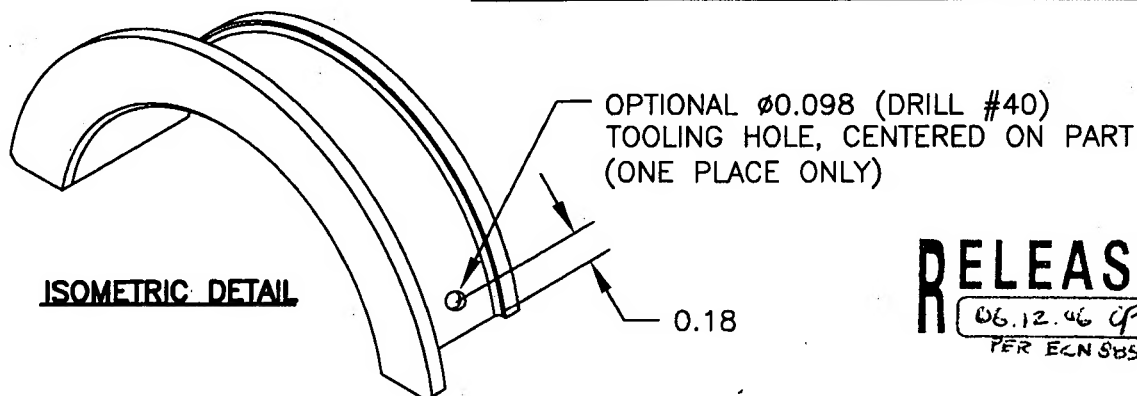
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.590	+/-0.010	1.590	✓			
R1.177	+0.005/-0.000	1.177	✓			
0.130	+/-0.010	0.127	✓			
0.080	+/-0.010	0.075	✓			
0.928	+/-0.010	0.931	✓			
0.100	+/-0.010	0.100	✓			
0.100	+/-0.010	0.100	✓			
1.39	+/-0.030	1.395	✓			

Measured by: BG	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07.06.11	Date: 07/06/11	Date:	N/A

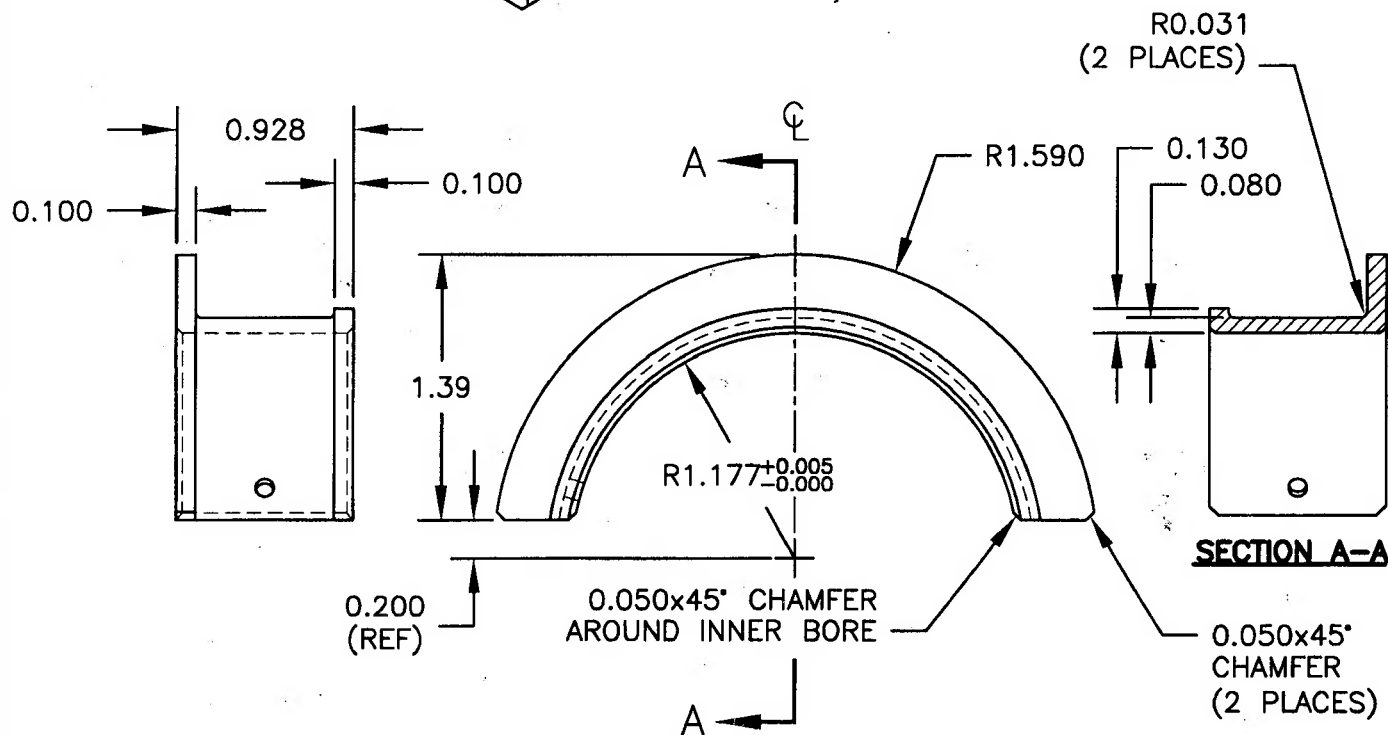
Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.03.29	Dwg Rev. updated	KJ/JLM [Signature]	[Signature]

DART

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ///	APPROVED ///	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



RELEASED
06.12.06 qp
PER ECN 085



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32205

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